

# Work Order ID 124000

September-05-14 9:10:42 AM

\*124000\*

Page 1

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Start Qty: 1.00

\*1\*

Required Date: 9/05/14

Req'd Qty: 1.00

\*1\*

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLS

Date: 1409-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

1.10.

100

Document Control

0.00

\*100\*

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

DAS  
38  
9-89

14-9-12

110

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod B128956

3-Grind End Plate flush

IX

Dh 14-9-9

CC 14-9-9

# Work-Order ID 124000

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Item ID: D350-591-312

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00				1		SEP 09 2014	DAS 24 9-89
*120*									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00				1		SEP 09 2014	DAS 24 9-89
*130*									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
*140*									
HandFinish	Memo	0.00							
Hand Finishing									

1 SEP 09 2014 DMC

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Item ID: D350-591-312 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 9/05/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/05/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
*150*									
QC	Memo	0.00							
Quality Control									
180		0.00							
*180*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 128756								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

1 6 14-9-10 DAS 34 9-89  
 1 6 14-9-10  
 CC 14-9-10

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Item ID: D350-591-312 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 9/05/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				↓	SEP 10 2014	DAS 24 9-89	
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				↓	SEP 10 2014	DAS 24 9-89	
210 <b>*210*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1	7/6 149-11		

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Item ID: D350-591-312 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 9/05/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/05/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>ML 128959</i> Memo START TIME: <i>10:10</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>10:40</i>	0.00 0.00							<i>1 16 14-9-11</i> DAS 34 9-89
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>1112981070</i> Memo	0.00 0.00							<i>x 1RH f M 100011</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>1</i> DAS 38 9-89 <i>14-9-11</i>

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Item ID: D350-591-312 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Heli-Access-Step™ RH  
 Start Date: 9/05/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/05/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
*250*									
Packaging	Memo	0.00				1/X	DAS 28 9-89	SEP 10 2014	
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
*260*									
QC	Memo	0.00				1		DAS 38 9-89	14-9-12
Quality Control									
270	Packaging	0.00							
*270*									
Packaging	Memo	0.00						DAS 08 9-89	SEP 12 2014
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>110</u>								

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Item ID: D350-591-312 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Heli-Access-Step™ RH  
Start Date: 9/05/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/05/14 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

14/9/16 *[Signature]*

*[Signature]* 9-15

# Picklist Print

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Page 1

Work Order ID: 124000

**\*124000\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.03.22New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D  
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1  
**\*D3272-1\***  
 Step

Manufactured No

110

Each

12.0000

1

1

\*\*

CC 14-8-9

Location

Loc Qty

Loc Code

WA003

12

B124001

(1x)

123348

10

123916

2

D3067-1  
**\*D3067-1\***  
 End Plate

Manufactured No

110

Each

402.0000

1

1

\*\*

CC 14-8-9

Location

Loc Qty

Loc Code

WA003

402

101785

67

102686

14

117776

171

119290

150

(1x)

D3219-1  
**\*D3219-1\***  
 Plate

Manufactured No

110

Each

167.0000

2

2

\*\*

CC 14-8-9

Location

Loc Qty

Loc Code

WA003

167

112125

8

114934

40

115339

119

(2x)



# Picklist Print

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Page 2

Work Order ID: 124000

**\*124000\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

✓ D3066-1

Manufactured No

180

Each

128.0000

2

2

**\*D3066-1\***

**\*\***

Spacer

Location

Loc Qty

Loc Code

WA003

128

106302

7

115867

29

115868

52

115869

40

2x 2x DL-14-9-10

✓ MS20600-AD4W4

Purchased No

180

Each

2,589.000

16

16

**\*MS20600-AD4W4\***

**\*\***

Rivets

Location

Loc Qty

Loc Code

ST310

2589

125577

215

M128899

2374

16 16x DL 14-9-10

✓ D3065-041

Manufactured No

180

Each

33.0000

1

1

**\*D3065-041\***

**\*\***

Step Leg Assembly

Location

Loc Qty

Loc Code

WA003

33

102830

6

109447

2

113075

2

123378

23

1x 1x DL 14-9-10

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Page 3

Work Order ID: 124000

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

**\*124000\***

**\*D350-591-312\***

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3067-1

Manufactured No

180

Each

402.0000

1

1

**\*D3067-1\***

End Plate

**\*\***

*Cx 14.9.10*

Location

Loc Qty

Loc Code

WA003

402

101785

67

102686

14

117776

171

119290

150

AN3-35A

Purchased No

250

Each

133.0000

2

2

**\*AN3-35A\***

Bolt

DAS  
38  
9-89

**\*\***

DAS  
28  
9-89

SEP 10 2014

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

123

m129706

23

m129934

100

D3235-1

Manufactured No

250

Each

343.0000

2

2

**\*D3235-1\***

Mounting Lug

DAS  
38  
9-89

**\*\***

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST519

343

102818

6

105939

17

108670

43

114441

54

116383

100

116384

53

116385

70

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Shop Packet Print

Page 3

# Picklist Print

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Page 4

Work Order ID: 124000

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

\*124000\*

\*D350-591-312\*

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3278-041

Manufactured No

250

Each

69.0000

1

1

\*D3278-041\*

Support Assembly

DAS

38

9-89

\*\*

DAS

28

9-89

SEP 10 2014

Location

Loc Qty

Loc Code

ST521

69

102349

1

109406

1

114169

39

114940

4

121431

24

1X

NAS1149D0463J

Purchased

No

250

Each

5,775.000

16

16

\*NAS1149D0463J\*

WASHER

DAS

38

9-89

DAS

38

\*\*

DAS

28

9-89

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

5290

16941

8

M126221

20

M127813

6

M127904

127

M128591

44

M128995

1500

M129390

3585

16X

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Shop Packet Print

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# Picklist Print

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Page 5

Work Order ID: 124000

**\*124000\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

250

Each

1,913.000

4

4

**DAS**  
**28**  
**9-89**

SEP 10 2014

**\*NAS1149D0563J\***

Washer

**DAS**  
**38**  
**9-89**

## Location

## Loc Qty

## Loc Code

GA	125	
m125807	125	
ST510a	1788	
m126319	100	
m128257	1688	

**\*\***

AN5-36A

Purchased

No

250

Each

91.0000

2

2

**DAS**  
**28**  
**9-89**

**\*AN5-36A\***

Bolt

**DAS**  
**38**  
**9-89**

## Location

## Loc Qty

## Loc Code

ST336	91	
M126105	1	
M127410	7	
M127460	83	

**\*\***

D2618

Manufactured

No

250

Each

211.0000

2

2

**\*\***

**\*D2618\***

Bushing

**DAS**  
**38**  
**9-89**

## Location

## Loc Qty

## Loc Code

ST008A	211	
103863	3	
114872	1	
123045	100	
97780	107	

**DAS**  
**28**  
**9-89**

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Work Order ID: 124000

**\*124000\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2230-3

Manufactured No

250

Each

442.0000

4

4

DAS  
28  
9-89

SEP 10 2014

**\*D2230-3\***

Mounting Lug

DAS  
38  
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

435

108668

1

109344

2

114151

1

114921

4

115583

146

116378

155

116379

126

4X

D2856-400

Manufactured No

250

f

208.0000

1.2

2

DAS  
28  
9-89

**\*D2856-400\***

Abrasion Strip 4" Wide (Per Foot)

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST426

208

117887

208

123583

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

3,082.000

2

2

DAS  
28  
9-89

**\*MS21042L3\***

Nut

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST307

3082

123900

948

M127410

11

M127831

41

M128401

42

M128754

2040

2X

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**\*124000\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

250

Each

613.0000

8 8

**\*AN4-13A\***

Bolt

DAS  
38  
9-89

\*\*

DAS  
28  
9-89

SEP 10 2014

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST515

577

m127432

36

m127817

22

m128739

519

8x

DAS  
28  
9-89

MS21042L5

Purchased

No

250

Each

636.0000

2

**\*MS21042L5\***

Nut

DAS  
38  
9-89

\*\*

Location

Loc Qty

Loc Code

ST307

636

125684

8

m127304

1

m127813

497

m128810

7

m129472

123

2x

DAS  
28  
9-89

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Work Order ID: 124000

**\*124000\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

250

Each

4,588.000

8

8

**\*MS21042L4\***

Locknut

DAS  
38  
9-89

\*\*

DAS  
28  
9-89

SEP 10 2014

## Location

## Loc Qty

## Loc Code

ST307

4588

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

891

m128300

80

m128798

999

m129472

1000

m129934

1500

8x

NAS1149D0363J

Purchased

No

250

Each

1,677.000

4

4

**\*NAS1149D0363J\***

Washer

DAS  
38  
9-89

\*\*

DAS  
28  
9-89

## Location

## Loc Qty

## Loc Code

GA

7

124392

7

ST276

5

m123441

5

ST510a

1665

m128429

1665

4x

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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WITHOUT NOTICE  
WORK ORDER  
NO. 124000 MJS

1709-05

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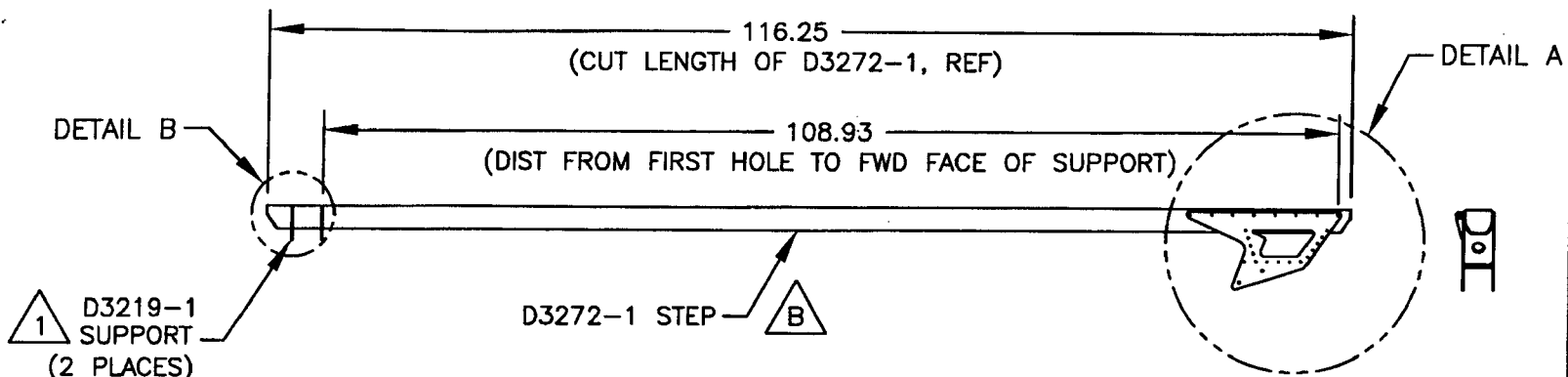
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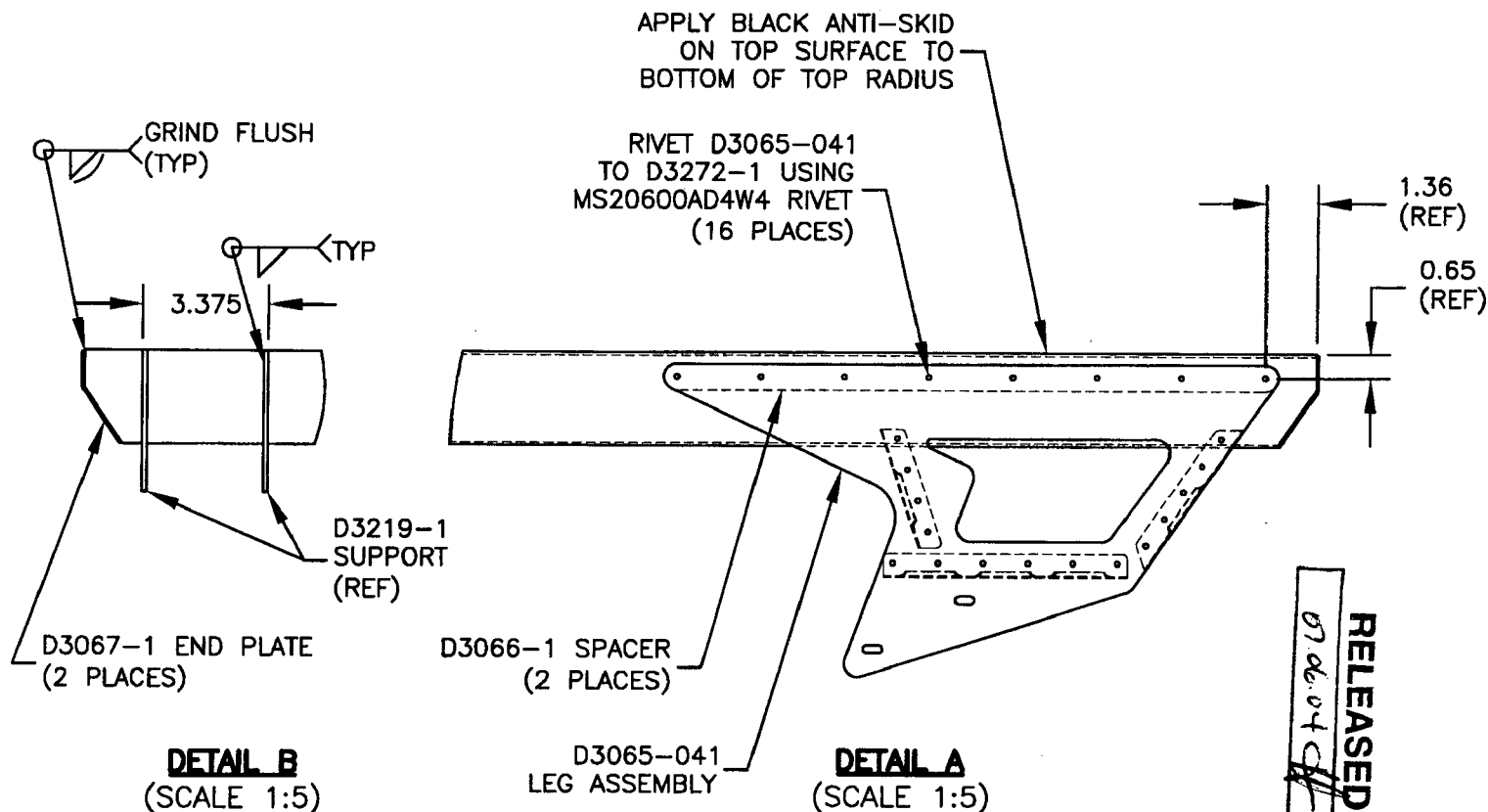


DESIGN	40	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20

RELEASED  
07.06.04



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

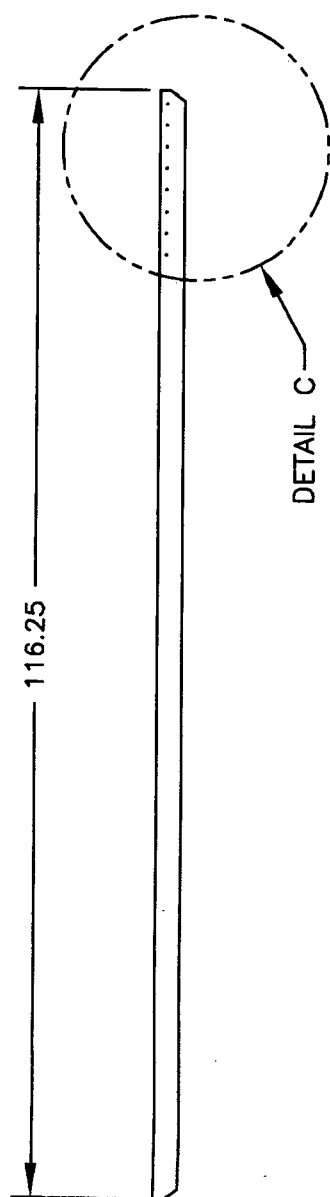




DESIGN 9P	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

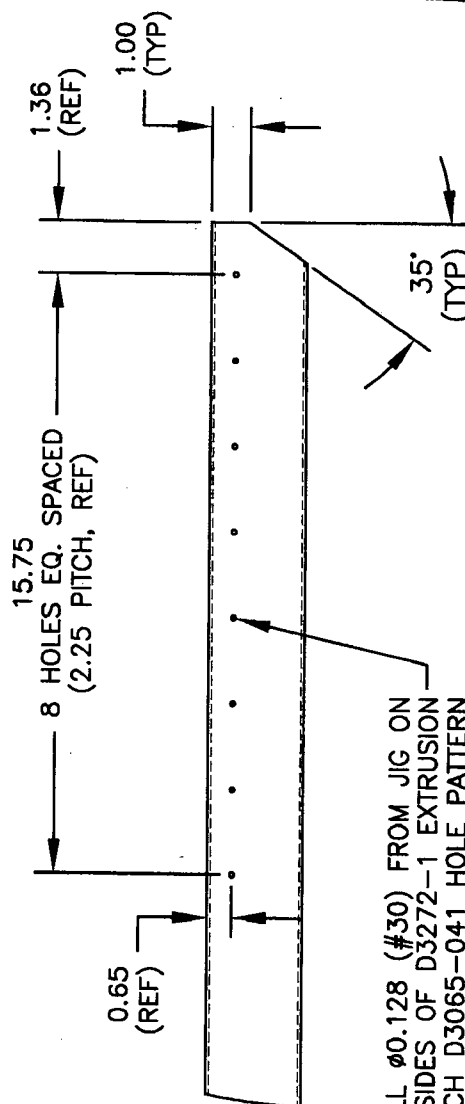
07.06.04 [Signature]



DETAIL C

**△ D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

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Work Order ID 124000

\*124000\*

Page 1

September 05-14 9:10:42 AM

Item ID: D350-591-312

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ RH

Start Date: 9/05/14

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 9/05/14

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plant:

Date: 14-09-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

11.10.

100

Document Control

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Doc. Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

ML 14-09-11

110

Large Fab

0.00

\*110\*

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod B178856

3-Grind End Plate flush

IX DL 14-9-9  
CC 14-9-9

REFERENCE ONLY

DAS  
38  
9-89

DART AEROSPACE LTD.

D350-591  
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G  
Date: 08.10.06